

Work Order ID 92990

November-13-12 9:51:35 AM

92990

Page 1

Item ID: D3875-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector

Start Date: 13/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3875	Rev A								
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
105		0.00							
105									
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo								
	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240° F</u>								
	Time IN: <u>7:00 am</u>								
	Time OUT: <u>7:00 am</u>								

DAS
07
289
12/11/13

DAS
07
289
12/11/13

Work Order ID 92990

November-13-12 9:51:35 AM

92990

Page 2

Item ID: D3875-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector

Start Date: 13/11/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110						x2			DAS 12/11/13
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435 Dwg Rev: <u>A</u> Folio Rev: <u>B</u> Visually inspect for proper formation and texture								
140		0.00							
140						x2			B 12/11/15
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
150						x2			B 12/11/15
QC	Memo	0.00							
Quality Control	Complete FAI document								

Work Order ID 92990

November-13-12 9:51:35 AM

92990

Page 3

Item ID: D3875-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 13/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

Handwritten notes and stamps:
 - Stamps: "AS 15 12/11/15" and "DAS 16 12/11/15"
 - Handwritten: "12/11/15" and "12/11/15"

Handwritten note: "12/11/20" with a circled "2"

Handwritten note: "12/11/20" with a signature and "ME 12-11-20"

Picklist Print

November-13-12 9:51:39 AM

Page 1

Work Order ID: 92990

92990

Parent Item: D3875-1

D3875-1

Parent Item Name: Floor Protector

Start Date: 13/11/2012

Required Date: 27/11/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	821.7749	9.84	19.68			

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

Loc Qty

821.7749406

821.774941

Loc Code

113127

19.68 sq ft.

DAS
07
12/11/15

DART AEROSPACE LTD		Work Order:	92990
Description: Floor Protector		Part Number:	D3875-1
Inspection Dwg: D3875	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

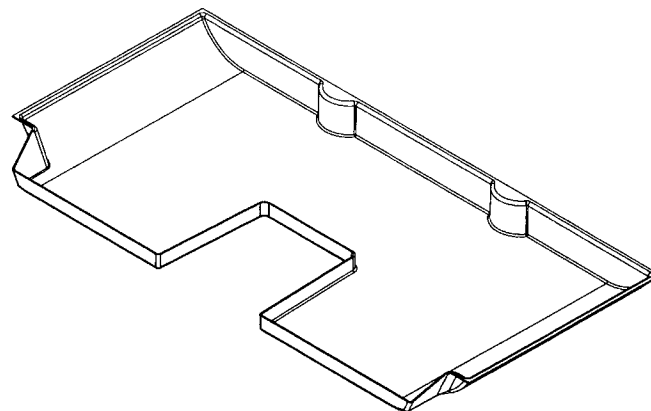
Measured by: BB Date: 12/11/15

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.081	✓		DL-01	
0.080	Min	0.085	✓		TH-DT	
45.2	+/-0.100	45.3	✓		DL-02	
21.8	+/-0.100	21.75	✓		DL-02	
1.4	+/-0.100	1.432	✓			

Measured by: BB Date: 12/11/15
Audited by: DA Date: 12/11/15
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	



D3875-1 FLOOR PROTECTOR (206B)

SENDER COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AGREEMENT
 WITHOUT NOTICE
 WORK ORDER

92990 MLJ

12-11-13

RELEASED
 29/05/05 NAB

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AG		
DRAWN	AG		
CHECKED	LS		
MFG. APPR.	TS		
APPROVED	TH		
DE APPR.	TH		
DATE	09.01.29		

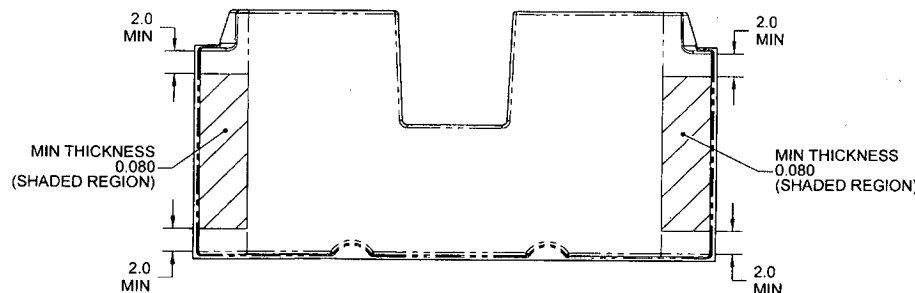
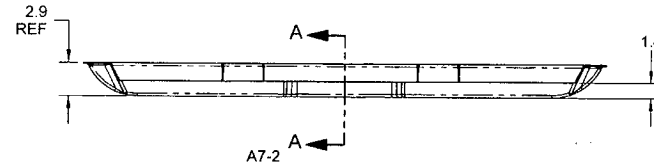
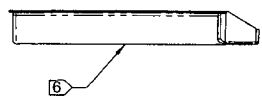
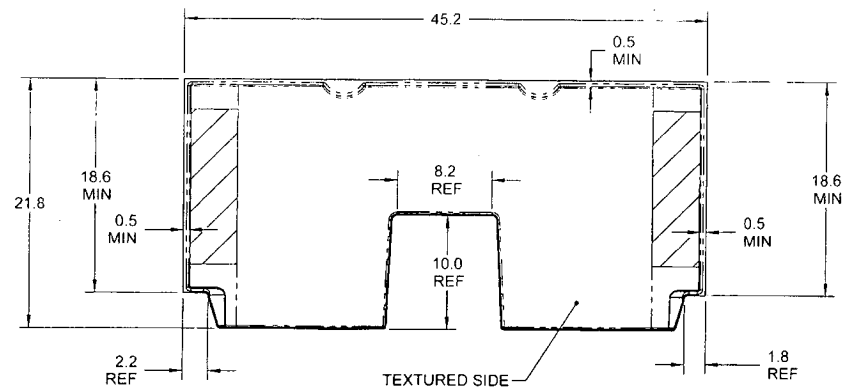
DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3875 REV. A
 SHEET 1 OF 2

TITLE FLOOR PROTECTOR (206B) SCALE NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD

92990



SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

RELEASED
09/05/05

DESIGN	REF	DART AEROSPACE LTD	
DRAWN	REF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REF	DRAWING NO. D3875	REV. A
MFG. APPR.	REF		SHEET 2 OF 2
APPROVED	REF	TITLE FLOOR PROTECTOR (206B)	SCALE NTS
DE APPR.	REF		
DATE	09.01.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	